

Work Order ID 70886

Thursday, June 16, 2011 3:35:51 PM



Page 1

Item ID: D2806-3

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 6/16/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2806

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA105 Rev: *[Signature]* & Dwg D2806 Rev: *[Signature]* ☐ 2-Deburr
per dwg D2806

DR 11-6-23 20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DR 11-6-23 20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B-A 11/06/23

20

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20 BL 10-6-24

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20X Ø M-14/06/24

150

Identify as per dwg & Stock Location: ST 20

0.00



Packaging

Memo

0.00

Packaging

JB 20 11/06/24

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 6/16/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27 J

ME

11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 3:35:57 PM

Page 1

Work Order ID: 70886

Parent Item: D2806-3

Parent Item Name: Bushing



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ B ☐ 05.03.11 ☐ Part now turned ☐ KJ/JLM
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6H1.000

Purchased

No

110

f

13.4180

0.0916

1.928421



Req 11.6-23

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

13.418

109478

1.721

116623

11.697

1.25

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	70886
Description: Bushing		Part Number:	D2806-3
Inspection Dwg: D2806	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.005	/		PP .02	
1.155	+/-0.010	1.153	/			
0.250	+/-0.010	.253	/			
0.063 x 45°	+/-0.010	.067	/			
0.080 x 45°	+/-0.010	.087	/			
0.495	+0.000/-0.005	.492	/			
0.750	+0.000/-0.005	.747	/			
Ø0.316	+0.005/-0.000	.316	/			
0.094	+/-0.005	.094	/			

Measured by: DR	Audited by: B.A	Prototype Approval:	N/A
Date: 11.6.23	Date: 11/06/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

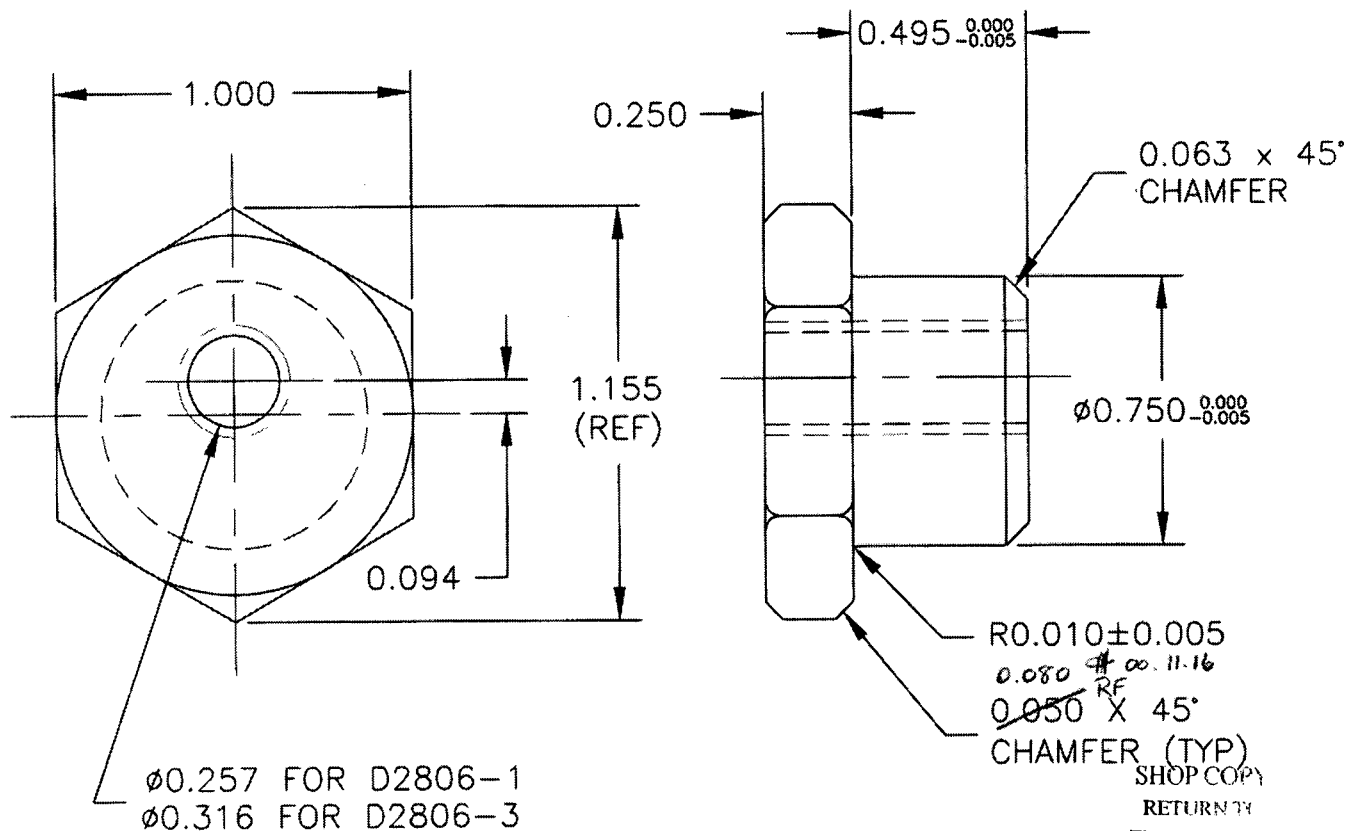
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70886

plh-06-16

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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